



Commodity Specification

TURKEY TACO FILLING

JULY 2002



Table of Contents

	Page
I. GENERAL	1
II. COMMODITY SPECIFICATION	1
A. Basic Requirements	1
1. Date Processed	1
2. Origin of Turkeys	1
3. Inspection	1
4. FSIS Requirements	2
5. Product Temperature	2
6. Pre-Bid/Production Samples	2
7. USDA Sampling Option	2
8. Turkey Products From Other Plants	2
B. Requirements for Turkey Products	3
1. Sources of Meat and Skin	3
2. Maximum Temperature	3
3. Cooling	3
4. Cooling Medium	3
5. Neck and Crop Skin	4
6. Requirements for Desinewing	4
7. Organoleptic Requirements and Defects	4
Table 1. Organoleptic Requirements and Defects for Meat and Skin	5
C. Formulation and Processing Requirements for Ground Turkey	5
1. Formulas	5
2. Skin	6
3. Fat Requirements	6
4. Processing and Size Reduction	6
5. Cooling Size-Reduced Turkey Products	7
6. Temperature of Size-Reduced Turkey Products	8
7. Organoleptic Requirements and Defects	8
Table 2. Organoleptic Requirements and Defects for Ground Turkey	9
8. Ground Turkey Rework	9
9. Freezing Ground Turkey	9
D. Lots and Sublots	10
1. Definition of a Lot	10
2. Definition of a Sublot	10
E. Fat Requirements for Ground Turkey	10

	Page
F. Sampling and Laboratory Analyses	10
1. Sampling	10
2. Samples for Laboratory Analyses	11
3. Laboratory Analyses	11
4. USDA Laboratories	12
5. Timely Receipt of Laboratory Results	12
6. Appeal of Laboratory Analyses	13
G. Contractor Analysis of Fat Content Program	13
H. Processing Ground Turkey Into Commodity	14
1. Prerequisites for Use of Ground Turkey	14
2. Processing Sequence	15
3. Formulation	15
4. Mixing	15
5. Cooking	15
6. Packaging	16
7. Packing	16
8. Organoleptic Requirements and Product Characteristics	17
Table 3. Organoleptic Requirements and Product Characteristics for Cooked Commodity	18
9. Reprocessing Cooked Commodity	18
10. Freezing	18
I. Metal Detection	19
1. Requirements	19
2. Operating Efficiency and Procedures	19
3. Contaminated Product	19
4. Other Detection Procedures	19
III. LABELING	19
A. USDA Labeling Requirements	20
1. Labeling Provisions	20
2. Printing Requirement	20
B. USDA Labeled Packages	20
C. USDA Labeled Shipping Containers	20
1. Recycle Symbol and Statement	20
2. Labeling and Marking Information	20
3. TOP PANEL - Labeling and Marking	20
4. ONE END Panel - Labeling and Marking	21
5. ONE SIDE Panel - Labeling and Marking	23
6. THE OTHER END Panel - Labeling and Marking	23
7. THE OTHER SIDE Panel - Labeling and Marking	23
8. Inventory Control Label	23
D. Use of Previously Printed USDA Labeling Materials	23
E. Commercial Labeling Requirements	23
1. Distributor Labels	23
2. Traceable Product	24
F. Additional Labeling Issues	24

	Page
IV. FINAL EXAMINATION OF PACKAGED AND PACKED COMMODITY	24
A. Material and Net Weight Compliance	24
1. Verification of Materials and Defects	24
2. Net Weight	25
B. Prerequisites for Loading and Shipping Frozen Commodity	26
1. Visual Inspection	26
2. Internal Product Temperature	26
C. Inspection and Checkloading	27
1. Requirements	27
2. Procedures	27
V. UNITIZATION	27
A. Pallets	27
B. Pallet Exchange	27
VI. SHIPMENT AND DELIVERY	28
A. Contract Compliance Stamp	28
B. Grading Certificate	28
1. Railcar or Piggyback	28
2. Trucks	28
C. Loading and Sealing of Vehicles	28
1. Railcar	28
2. Truck or Piggyback	28
D. Delivery Notification	28
1. In-Plant Deliveries	29
2. Delivery In Storage	29
E. Split Deliveries	29
VII. DESTINATION EXAMINATION	29
A. Commodity Requirements	29
B. Temperature	30
EXHIBITS	31-33
EXHIBIT 1 - "Please Recycle" Symbol and Statement	31
EXHIBIT 2 - USDA Labeled Shipping Containers	32
EXHIBIT 3 - USDA Labeling Information for Turkey Taco Filling.	33
USDA SYMBOL	Back of Specification

I. GENERAL

Frozen cooked turkey taco filling (commodity) produced under this Specification will be packaged and packed in the following form as specified in the contract:

Turkey Taco Filling (231330) - Frozen cooked turkey taco filling, produced from ground turkey (ready-to-cook nonbasted, young turkeys or turkey products, and turkey skin), and spices/seasonings. The commodity must be packaged in 3- or 5-pound (1.36- or 2.27-kg) packages to a net weight of 30 pounds (13.61 kg) in each fiberboard shipping container. A purchase unit will consist of 1,300 shipping containers totaling 39,000 pounds (17,690 kg).

II. COMMODITY SPECIFICATION

A. Basic Requirements

1. Date Processed. The commodity must not be processed prior to the date of the contract.

2. Origin of Turkeys. The commodity must be produced and processed from ready-to-cook turkeys, turkey parts, boneless parts, meat, and skin (turkey products) which were produced, raised, and processed in the United States, its territories or possessions, the Commonwealth of Puerto Rico, or the Trust Territories of the Pacific Islands. If the contractor processes or handles turkey products originating from sources other than the United States, its territories or possessions, Puerto Rico, or the Trust Territories of the Pacific Islands, the contractor must have an acceptable identification and segregation plan for those turkey products to ensure they are not used in the commodities produced under this Specification. This plan must be made available to a representative of the Grading Branch, Poultry Programs, AMS, USDA (grader), and the Contracting Officer or agent thereof upon request. The contractor must ensure that both the contractor and subcontractor(s) maintain records such as invoices, or production and inventory records evidencing product origin, and make such records available for review by the USDA grader or other Government official(s) in accordance with Article 76 of USDA-1.

3. Inspection. Processing operations must comply with Poultry Products Inspection Regulations (9 C.F.R. part 381) and be under the supervision of a representative of the USDA Food Safety and Inspection Service (FSIS) (inspector). Inspection for contract and specification compliance will be in accordance with the Regulations Governing the Voluntary Grading of Poultry Products and Rabbit Products (7 C.F.R. part 70) and the U.S. Classes, Standards, and Grades for Poultry (AMS 70.200 *et seq.*) under the supervision of a USDA grader. The USDA grader will be responsible for certification of compliance with the requirements of this Specification for chilled turkey products; size-reduced turkey products; ground turkey; processing, formulation, packaging, cooking of the commodity, and packing; turkey taco filling; freezing; labeling and marking; sampling; laboratory results; net weight; and checkloading.

II.A.

4. FSIS Requirements. **The commodity must be produced and processed in an FSIS Federally inspected establishment, be accurately marked and/or labeled, and meet all FSIS regulatory requirements, including all microbiological testing requirements, currently in place.**

5. Product Temperature. The temperature of raw turkey products, raw size-reduced turkey products (ground turkey), and cooked commodity, unless otherwise specified, must comply with FSIS regulations (9 C.F.R. § 381.66) and FSIS directives and guidelines for cooked products throughout all operations including transportation between plants.

6. Pre-Bid/Production Samples. Sample preparation will be in accordance with Poultry Programs' guidelines. Instructions in the Poultry Grader's Handbook, Section 10, VI. Pre-Bid Sample Certification, will be used to certify the pre-bid samples. Pre-bid samples will be subject to USDA, AMS supervision for formulation and processing procedures only. See additional information regarding pre-bid requirements in Poultry Programs' current Announcement for Turkey Taco Filling.

a. Pre-bid samples, formulation, and production procedures. A pre-bid sample and written documentation of the actual formulation, production procedures, and equipment used (technical proposal) must be submitted to USDA for review and approval prior to the award of contracts.

(1) The same formulation, production procedures, and equipment must be used by the contractor/processor for the production of the pre-bid sample, as will be used for the commodity. Changes made to the formulation, production procedures, and equipment after commodity processing has begun will require re-submitting (pre-bid) samples using the new formulation, procedures, or equipment for evaluation and approval.

(2) The sample and technical proposal will be evaluated in accordance with the standards for evaluation factors as written in Poultry Programs' "Source Selection Plan for Turkey Taco Filling 'Sample Prototype' and 'Technical Proposal'," dated July 2002.

b. Production samples. The production sample will also be evaluated to ensure compliance with the product characteristics found in Table 3 (II.H.8.).

7. USDA Sampling Option. USDA may select additional product for further inspection or may draw samples for laboratory analyses.

8. Turkey Products From Other Plants. Turkey and turkey products may be transferred or obtained from other plants, provided they: (a) have been processed, handled, and identified in accordance with this Specification, and (b) comply with the nonbasted, organoleptic, and other applicable requirements of this Specification as evidenced by USDA certification.

II.A.8.

a. Type, class, and specific name of the product, part, boneless part, or meat; date slaughtered or date placed in frozen storage; and the USDA-assigned plant number must be shown on each shipping container.

b. The chilled and/or frozen turkey and turkey products must be maintained at an internal product temperature not higher than 40 °F (4.4 °C) when shipped from the origin plant and when received at the destination plant.

B. Requirements for Turkey Products

1. Sources of Meat and Skin. The commodity must be produced from meat (with skin attached or without skin) from nonbasted carcasses and parts (no solution or ingredients added).

a. Chilled. The chilled turkey and bone-in, skin-on or skinless turkey parts must be deboned and used in the finished cooked commodity within 7 calendar days after the day the turkeys are slaughtered. Within this 7-day timeframe, deboned meat (with skin attached or without skin) from turkey and turkey parts must be used in the ground turkey within 36 hours after deboning, and the ground turkey must be fabricated into the cooked commodity within 72 hours after grinding.

b. Frozen. Frozen meat (bone-in or boneless and skin-on or skinless turkey carcasses and parts) may be used when: (1) produced from freshly slaughtered turkeys, (2) packaged to protect against quality deterioration during storage and identified so the time in storage and the class, kind, and specific deboned turkey product can be determined, (3) held not more than 60 days in frozen storage, and (4) the product shows no evidence of thawing and refreezing or freezer deterioration. Time from the start of the thawing process to the finished cooked commodity must be no longer than 7 days.

c. Skin. Skin that is not attached to meat must not be used in the commodity.

2. Maximum Temperature. The temperature of the carcasses, bone-in or boneless parts, and skin must not exceed 55 °F (12.8 °C) at any time during preparation or processing of these turkey products into ground turkey.

3. Cooling. Carcasses and bone-in or boneless parts which are not used in the ground turkey on a continuous basis, must be cooled by cooling methods or media that ensure that the internal product temperature is continuously lowered to not higher than 40 °F (4.4 °C) and not lower than 26 °F (-3.3 °C).

4. Cooling Medium.

a. Cooling methods and media (e.g., use of carbon dioxide (CO₂) or liquid nitrogen (N₂)) may be used to maintain the temperature of meat and parts.

II.B.4.

b. Water, refrigerated water, slush ice and water, or ice used to cool or maintain the temperature of meat or parts must not be incorporated into the ground turkey. Liquid associated with normal product weepage is acceptable.

5. Neck and Crop Skin. Neck skin cannot be used in ground turkey.

6. Requirements for Desinewing. The long bone (tibiotarsus) must be removed from the drumsticks before the drumsticks (with or without attached skin) are processed through a desinewer to remove the tendons.

7. Organoleptic Requirements and Defects.

a. Organoleptic requirements. Meat, boneless parts, deboned drumsticks, and parts (bone-in) will be examined on a continuous basis for the organoleptic requirements listed in Table 1 below. Any product that does not comply with the organoleptic requirements will be rejected for use under this Specification.

b. Defects.

(1) A sample of 30 pieces of meat, boneless parts, deboned drumsticks, and parts (bone-in) will be examined for the defects listed in Table 1 before formulation or size reduction. The frequency of sampling and the number of defects allowed will be those outlined in Poultry Programs' Sample Plan Level 1 (SPL-1). If the sample has more defects than the maximum tolerance for the sample plan, the product the sample represents will be rejected.

(2) If simultaneous size-reduction and bone removal systems will be used, boneless parts and deboned drumsticks shall be examined for the applicable defects listed in Table 1 except for the presence of bone or bone-like material, hard tendinous material, or cartilage (gristle).

Table 1. Organoleptic Requirements and Defects for Meat and Skin

Organoleptic Requirements:	Criteria: Must be free from rancidity; free of fruity, sulfide-like, cardboardy, tallowy, oily, oxidized, metallic, chlorine, or other off or foreign odors; free of foreign materials (e.g., glass, paper, rubber, metal); must show no evidence of mishandling or deterioration; and must have a bright color with no evidence of dehydration or thawing and refreezing.
Defects - All Meat and Parts (With Skin Attached or Without Skin), and Skin:	<p>A flesh bruise on meat or on a part which exceeds an area equivalent to the area of a circle with a diameter of 0.75 inch (1.91 cm).</p> <p>Large blood clots on the meat or on a part which exceed an area equivalent to the area of a circle with a diameter of 0.25 inch (0.64 cm).</p> <p>Skin that is not attached to the meat.</p> <p>A defect for discolorations in the meat or skin is when the aggregate area of all discolorations, which are moderate in intensity exceeds an area equivalent to the area of a circle having a diameter of 1.50 inches (3.81 cm).</p>
Defects - Bone In Parts: (With Skin Attached or Without Skin)	More than one-third of the meat missing on a bone-in part.
Defects - Boneless Drumstick Meat: (With Skin Attached or Without Skin)	Bone or bone-like material, except that the knuckle bone (patella) may be present.
Defects - Other Boneless Meat: (With Skin Attached or Without Skin)	<p>Bone or bone-like material, hard tendon or tendinous material, or cartilage (gristle).</p> <p>A boneless thigh with more than one-half of the meat missing.</p>

C. Formulation and Processing Requirements for Ground Turkey

1. Formulas. Ground turkey must be formulated according to one of the following two formulas:

a. Meat and skin basis. Formula based on deboned meat (with skin attached or without skin) or boneless parts. The maximum amount that can be used in a formula is specified when applicable.

(1) White meat (with skin attached or without skin). The maximum amount of white meat (with or without attached skin) that can be used in a formula is 30 percent of the total weight of the formula. The white meat may be wing meat or scapula portion. Other white meat trimmed from the frames (white frame meat) may be used. White frame meat is limited to no more than 3 percent of the total weight of the formula.

II.C.1.

(2) Dark meat (with skin attached or without skin). Boneless thighs or boneless and skinless thighs (not more than one-half of meat missing) or desinewed drumstick meat may be used. Dark meat trimmed from the frame (dark frame meat) may be used. Dark frame meat is limited to not more than 2 percent of the total weight of the formula.

b. Bone-in basis. Formula based on bone-in parts (with or without attached skin). The maximum amount of a specific part which can be used in a formula is specified when applicable. These parts are for preparation of ground turkey by mechanically removing the meat and skin directly from the parts and simultaneously reducing the size of the meat and skin (mechanical and simultaneous reduction process).

(1) Drumsticks. Drumsticks may be used.

(2) Thighs. Thighs may be used.

(3) Wings. Wings may be whole wings, the first portions, or attached first and second portions. Wing tips can only be used when they are part of a whole wing. The maximum amount of wings or wing portions which can be used in a formula is 40 percent of the total weight of the formula.

2. Skin. Skin that is attached to the chilled or frozen meat or parts may be formulated according to II.C.1. in natural proportion only. Chilled or frozen skin that is not attached to the meat must not be added.

3. Fat Requirements. The ground turkey must be formulated so the fat content complies with II.E.

4. Processing and Size Reduction.

a. Processing. The meat (with skin attached or without skin) must be processed and blended, as applicable, and reduced in size by equipment and procedures that produce a uniform blend of meat and skin with muscle fibers and strand-like texture, and having the functional properties of ground turkey.

b. Size reduction. Meat (with skin attached or without skin) for the ground turkey must be reduced in size by one of the following procedures:

(1) Ground through a plate with holes 0.125 inch (1/8 inch) (3.175 mm) in diameter;

(2) Desinewed or reduced through a desinewer plate or screen with holes 0.0591 inch to 0.0787 inch (1.5 mm to 2.0 mm) in diameter or as required to ensure equivalent removal of tendons present in the meat;

II.C.4.

(3) Reduced through a head consisting of a series of screen plates with rectangular-like openings that measure: (a) 0.018 to 0.020 inch by 0.765 to 0.831 inch and (b) 0.018 to 0.020 inch by 0.255 to 0.302 inch. (Measurement of the rectangular-like openings in metric units: (a) 0.4572 to 0.5080 mm by 19.4310 to 21.1074 mm and (b) 0.4572 to 0.5080 mm by 6.4770 to 7.6708 mm.) The screen plates with the smaller openings will be positioned at the exit end of the auger and the number of these screen plates cannot be more than 12 percent of the total number of screen plates in the head; or

(4) Ground through a plate with holes 2 inches (5.08 cm) in diameter followed by size reduction through a stainless steel cylinder or screen with a series of round openings which divide the surface into thirds. Two-thirds (2/3) of the surface will have openings which measure 0.050 inch (1.27 mm). The exit end (the final 1/3) of the surface will be blank (no openings).

For mechanical removal and simultaneous reduction process, the contractor must give the USDA grader the model of the machine, the size of the cylinder screen or screen plates, the number of each size and the sequence of the screen plates which will be used to produce size-reduced meat and skin for use under this Specification. In addition, the contractor must have established control procedures to ensure the cylinder screen or screen plates are in the correct position, the screen plates are in the correct sequence, and that the cylinder screen or screen plates and the auger are aligned and maintained in an operating condition that will continuously produce a product which complies with the texture criteria and other requirements of this Specification. These control procedures must be reviewed and found acceptable by supervisory personnel of the Grading Branch, Poultry Programs, AMS, before size-reduced meat and skin can be used as ground turkey under this Specification.

c. Size reduction equipment. Any bent, broken, or defective blade, cylinder, screen, or plate must be replaced before the size reduction equipment can be used for reducing meat and skin.

d. Size-reduced skin. Any skin that is removed from the meat must not be used in the commodity.

e. Unacceptable size-reduced products. Meat and skin which cannot be used in the ground turkey: (1) comminuted meat; (2) any skin that is not attached to the meat; (3) meat (with skin attached or without skin) reduced to an emulsified or pasty consistency; (4) meat (with skin attached or without skin) which developed a discoloration during size-reduction process.

5. Cooling Size-Reduced Turkey Products. Cooling methods and media (e.g., use of CO₂ or N₂) may be used before, during, or after size reduction. Ice or ice water must not be used to lower the temperature of the ground product.

II.C.

6. Temperature of Size-Reduced Turkey Products. Temperature of ground turkey or any size-reduced component of the product (ground, desinewed, or mechanically reduced meat and skin) hereinafter referred to as “ground turkey/product” must not exceed 55 °F (12.8 °C).

7. Organoleptic Requirements and Defects.

a. Organoleptic requirements. The ground turkey will be examined on a continuous basis for the organoleptic requirements listed in Table 2. Any ground turkey that does not comply with the organoleptic requirements will be rejected for use under this Specification.

b. Defects. A 5-pound (2.27-kg) sample of ground turkey will be examined for the defects listed in Table 2 below prior to formulating into the commodity. The defect requirements will be examined in the fresh state.

(1) The examination for bone will be made separately from the examination for other defects.

(2) Regardless of the kind and number of defects (within Table 2) found, any sample containing bone and bone-like material will be cause for rejection of the product the sample represents.

(3) The frequency of sampling and the number of defects allowed will be those outlined in Poultry Programs’ Sample Plan Level 2 (SPL-2).

(4) If the sample contains bone or bone-like material, or has more defects than the maximum tolerance for the sample plan, the product the sample represents will be rejected.

Table 2. Organoleptic Requirements and Defects for Ground Turkey

Organoleptic Requirements:	<p>Must have: (1) muscle fibers and a strand-like texture and (2) a uniform light and bright color with no discoloration or dehydration.</p> <p>Must not have: (1) the texture of comminuted meat and skin, (2) a gritty texture, or (3) an emulsified or pasty consistency.</p> <p>Must be free of: (1) rancidity; (2) sour, stale, fruity, sulfide-like, cardboardy, tallowy, oily, oxidized, metallic, acidic, or other off or foreign odors; and (3) foreign materials (e.g., glass, paper, rubber, metal).</p>
Defects:	
Bone:	Must be free of: bone and bone-like material.
Other:	Must be free of: tendons, cartilage (gristle), and tendinous or ligamentous material which exceed 0.50 inch (1.27 cm) in any dimension.

8. Ground Turkey Rework.

a. Eligible product. Ground turkey may be reworked provided: (1) the temperature of the ground turkey has not exceeded 50 °F (10 °C) and has been maintained at that temperature or lower, (2) it complies with organoleptic requirements of II.C.7., and (3) it is incorporated into batches of ground turkey within 12 hours.

b. Time and temperature requirements. Additionally, ground turkey which has been chilled to not higher than 40 °F (4.4 °C) or lower than 26 °F (-3.3 °C), packaged, and maintained at a product temperature of not higher than 40 °F (4.4 °C) or lower than 26 °F (-3.3 °C) may be reworked within 72 hours from the end of the shift it was produced. When the chilled ground turkey is reworked, the temperature of the commodity must not exceed 40 °F (4.4 °C) during tempering.

9. Freezing Ground Turkey. If the ground turkey is frozen prior to being processed into the finished commodity, the ground turkey must be packaged and/or packed (to protect against quality deterioration) and continuously lowered to an internal temperature of 0 °F (-17.8 °C) or lower within 72 hours from the time of entering the freezer. If any sample of packaged ground turkey does not comply with the freezing requirements, the product or lot the sample represents will be rejected for use under this Specification.

II.

D. Lots and Sublots

1. Definition of a Lot.

- a. A lot is the amount of ground turkey produced during a processing shift.
- b. The ground turkey will be: (1) sampled for laboratory analyses and analyzed for compliance with fat content requirements, and (2) accepted or rejected on a lot basis.

2. Definition of a Sublot.

a. A lot may be separated into sublots for the purpose of sampling and analyzing for compliance with the fat content requirements. If this option is used, the ground turkey must be sublotted on the basis of consecutively produced: (1) shipping containers, or (2) pallets. The sublots of containers or pallets must be consecutively identified prior to formulation.

b. Ground turkey sampled and analyzed on the basis of sublots will be accepted or rejected on a sublot basis.

E. Fat Requirements for Ground Turkey

A lot or sublot (as defined in II.D.1. and II.D.2.) of ground turkey must contain no more than an average of 13.0 percent fat.

F. Sampling and Laboratory Analyses

1. Sampling.

a. A lot. The number of containers of ground turkey (fresh state) to be drawn from each lot will be as follows:

<u>Number of Containers in Lot</u>	<u>Number of Containers</u>
250 or less	8
251 - 500	12
501 - 1,000	16
1,001 - 2,000	24
Over 2,000	36

II.F.1.

b. A subplot. A minimum of four (4) containers will be drawn from each subplot. The total number of containers drawn from each subplot must be a multiple of four. The total number of containers drawn from all sublots in a lot must equal or exceed those specified for the appropriate size lot described in paragraph a.

2. Samples for Laboratory Analyses.

a. The USDA grader will randomly draw samples for fat content analysis from each lot or subplot and prepare samples as follows: The USDA grader will draw an 8-ounce (226.8 g) sample of ground turkey at random from each sample container and separate it into three ((approximately equal) 2.5-ounce (70.87 g)) sample portions.

b. Each portion will be placed in a moisture-proof sample bag.

c. The three portions of each sample will be used as follows:

--one for fat analysis at a USDA or USDA-contracted laboratory.

--one for the contractor.

--one for a reserve sample.

d. Samples will be kept in a freezer under the USDA grader's control until all samples are drawn and prepared for the lot or subplot.

(1) The reserve samples will be retained in a freezer under the control of the USDA grader. Reserve samples will be used for laboratory analyses when: (a) the original samples are lost; (b) the original samples arrive at the USDA laboratory in a condition that does not permit accurate analyses; or (c) requested by the Grading Branch, Poultry Programs, Washington, D.C.

(2) The samples for the contractor will be given to the contractor after the lot or subplot has been produced and all the samples for the lot or subplot have been drawn and prepared.

e. Samples which are not used by USDA will be returned to the contractor and may be reworked in accordance with II.C.8.

3. Laboratory Analyses.

a. The USDA or USDA-contracted laboratory will equally combine the samples

submitted for a lot or subplot in numerical sequence into four composite samples.

II.F.3.

b. The USDA or USDA-contracted laboratory will grind and mix each composite sample twice into a homogeneous mixture.

c. Each composite will be analyzed in duplicate for fat. The USDA or USDA-contracted laboratory will report the result for each duplicate to the nearest 100th of a percent and the average for each composite to the nearest 10th of a percent on the USDA certificate. In addition, the USDA or USDA-contracted laboratory will average the results of the composites and report the average for the lot or subplot to the nearest 10th of a percent on the USDA certificate, except when the average result for any one composite sample exceeds 13.0 percent.

d. Chemical analyses will be in accordance with the following methods found in the "Official Methods of Analysis," of the AOAC International, Seventeenth Edition, 2000, Chapter 39: "Meat and Meat Products," Subchapter 1, Sections 39.1.05 (Method 960.39), 39.1.06 (Method 976.21), and 39.1.07 (Method 985.15).

<u>Finished Product</u>	<u>Test Method</u>
Fat	Petroleum ether method, Rapid specific gravity method, or Rapid microwave-solvent extraction method

4. USDA Laboratories. The samples for laboratory analyses may be submitted to any one of the USDA or USDA-contracted laboratories listed below, except when AMS determines that condition or workload of a specific laboratory does not permit the prompt handling of samples. All costs incurred for shipping the samples and the laboratory analyses will be paid by the contractor.

USDA, AMS, Science and Technology Programs
Eastern Laboratory
645 Cox Road
Gastonia, North Carolina 28054
Telephone (704) 867-3873

Laboratory Services Division
Minnesota State Department of Agriculture
90 West Plato Boulevard, Room 241
St. Paul, Minnesota 55107-2094
Telephone (651) 297-1901

Laboratory Services Division
Oregon Department of Agriculture
1207 Northwest Naito Parkway, Suite 204
Portland, Oregon 97209-2835
Telephone (503) 872-6644

5. Timely Receipt of Laboratory Results. The contractor must present the ground turkey to USDA so the product may be sampled, the samples sent to the USDA or USDA-contracted laboratory, and the laboratory analyses performed in time for the laboratory results to be available for the contractor to meet the shipment or delivery requirements of the contract. If laboratory results are received by the contractor later than 7 calendar days,

excluding Sundays and Federal Holidays, from the receipt of the samples by the USDA or USDA-contracted laboratory, the number of days' delay will be added to the shipment or delivery period before liquidated damages for late shipment or delivery will be assessed.

II.F.

6. Appeal of Laboratory Analyses. An appeal of original laboratory analyses for a lot or subplot may be authorized by the Grading Branch, Poultry Programs, Washington, D.C. The appeal must be filed and made in accordance with the provisions for an appeal in 7 C.F.R. part 70. Only one appeal per lot or subplot is permitted.

a. For the appeal, a lot or subplot will be sampled and samples prepared by one of the following procedures:

(1) When the reserve samples are available, the USDA grader will randomly draw from the lot or subplot the same number of samples as drawn during original sampling and prepare the samples as outlined in paragraphs II.F.1. and II.F.2. These samples, plus the reserve samples previously prepared during the original sampling of the lot, or subplot, will be submitted for fat analyses.

(2) When the reserve samples are not available, the USDA grader will randomly draw twice the number of samples required in paragraph II.F.1. from the lot or subplot. Samples will be prepared as outlined in paragraph II.F.2. and submitted for fat analysis.

b. The samples for the appeal will be submitted to the USDA or USDA-contracted laboratory where the original fat analyses were performed.

c. The USDA or USDA-contracted laboratory will combine the samples into twice the number of composites described in paragraph II.F.3.c. and analyze each of the composite samples for fat content. The results will be reported as outlined in paragraph II.F.3.c.

d. The laboratory results of the samples for the appeal will supersede those of the original analyses and will be final.

G. Contractor Analysis of Fat Content Program

As an alternative method of sampling and laboratory analyses detailed in section II.F., the contractor may elect to participate in the Contractor Analysis of Fat Content (CAFC) program dated August 2001. AMS has developed this program to permit the use of contractor results to determine compliance with fat content requirements. Any questions about this program should be referred to the Contracting Officer at the following address:

Contracting Officer, Commodity Procurement Branch
Poultry Programs, AMS, U.S. Department of Agriculture
Rm. 3941-South Bldg., STOP 0260

1400 Independence Avenue, SW
Washington, D.C. 20250
Telephone: (202) 720-7693
Fax: (202) 720-5871

II.G.

The Contracting Officer will provide the procedures for participation in the CAFC program. The contractor must comply with the: (a) requirements in this Specification (excluding section II.F.), and (b) alternate sampling procedures, lab analyses, and other provisions of the CAFC Program.

H. Processing Ground Turkey into Commodity

1. Prerequisites for Use of Ground Turkey.

a. Temperature. Ground turkey that does not comply with the temperature requirements of this section will be rejected for use under this Specification.

(1) The internal product temperature of ground turkey must be not higher than 40 °F (4.4 °C) and not lower than 26 °F (-3.3 °C) before it is processed into the commodity and will be determined just before it is formulated and mixed with spices and flavorings. Unless otherwise specified, chilled ground turkey must be fabricated into the cooked commodity within 72 hours after grinding.

(2) Frozen ground turkey may be used when: (a) packaged to protect against quality deterioration during storage and identified so the time in storage can be determined; (b) held not more than 60 days in frozen storage if produced from freshly slaughtered turkeys, carcasses, and parts; (c) held not more than 30 days in frozen storage if produced from frozen turkeys, carcasses, and parts; (d) the product shows no evidence of thawing and refreezing or freezer deterioration; and (e) the product temperature is not higher than 40 °F (4.4 °C) and not lower than 26 °F (-3.3 °C) during tempering or prior to processing into the commodity. After thawing, the ground turkey must be used in the production of commodity within 36 hours.

b. Ground turkey from other plants. Ground turkey may be transferred or obtained from other plants to produce the commodity, provided it is: (1) processed, handled, and identified in accordance with this Specification and meets the temperature requirements outlined in II.H.1.a. above, and (2) processed from turkey products which comply with the nonbasted, organoleptic, and other applicable requirements of this Specification for turkey products as evidenced by USDA certification.

(1) Type, class, specific name of the product, date slaughtered or placed in frozen storage, and the USDA-assigned plant number must be shown on each shipping container of ground turkey.

(2) The chilled and/or frozen ground turkey must be maintained at an

internal product temperature not higher than 40 °F (4.4 °C) when shipped from the origin plant and when received at the destination plant.

II.H.1.

(3) Compliance of the ground turkey with fat content requirements (II.E.) must be in accordance with this Specification and may be made prior to transfer of ground turkey (in accordance with II.D. thru II.F. of this Specification) by the Supplier.

2. Processing Sequence. Commodity processing must follow the sequence stated within this paragraph (II.H.2.). Unless otherwise specified, ground turkey processing, turkey taco formulation, mixing, packaging then cooking or cooking then packaging (or other packaging/cooking alternative), chilling, and freezing of the commodity must be a continuous process that complies with the time and temperature requirements of this Specification. Formulation and mixing may be accomplished during the cooking processes.

3. Formulation. Proportions of ingredients required in preparing the commodities are as follows:

	<u>Percentage</u>
Ground Turkey (minimum)	74.00
Water (maximum)	14.00
Spices/Flavorings /Other Ingredients Formulation	4.00 - 6.00
Soy Protein (maximum percent of total formula)	<u>6.00</u>
	100.00

a. "Other ingredients" may include sodium phosphate. Kind and amount of restricted phosphates must be in accordance with FSIS regulations (9 C.F.R. § 424.21(c)).

b. Spices/flavorings must be the types used in conjunction with mild turkey taco flavoring. Soy protein used must be in a dry form (not hydrated) only. Soy protein used in the spices/flavorings/other ingredients formulation and/or the formula must not exceed 6 percent of the total formula. The contractor must furnish the USDA grader a statement by the manufacturer certifying the spices, flavorings, and other ingredients formulation for compliance with this Specification prior to production.

c. Processing aids (e.g., anti-caking agents, anti-dusting agents, or other manufacturing aids) are allowed if used and labeled in accordance with FSIS requirements. If processing agents are used, the ingredients and amount of ingredients listed in the formulation (II.H.3.) must remain the same.

4. Mixing. A uniform blend of ground turkey, water, and spices/flavorings must be achieved by mechanically mixing all ingredients prior to packaging.

5. Cooking.

a. Formulated raw commodity may be cooked prior to or after packaging (or other packaging/cooking alternative) in accordance with the processing sequence provided in II.H.2.

II.H.5.

b. The commodity must be cooked in accordance with FSIS regulations (9 C.F.R. § 381.150), and must reach an internal temperature of at least 160 °F (71.1 °C) during cooking. The time and temperature of cooking must provide cooked commodity that complies with II.H.8.

6. Packaging. All packaging materials must be new and clean, and must not impart objectionable odors or flavors to the commodity.

a. Packaging materials.

(1) The commodity must be packaged in a plastic-film bags. The bags must be safe (not adulterated or injurious to health) for use in contact with food products. The safety of food-contact packaging materials will be in accordance with 9 C.F.R. § 381.144.

(2) The plastic-film bags must be boil-able and steam-able, have the capability of packaging formulated product during or after cooking the commodity, and have the capability of freezing the commodity as required within this Specification. The bags must be made of water-proof film with oxygen barrier properties, and have: (a) wall thickness of not less than 4 mil (0.004 inch); (b) low-temperature flexibility (not brittle) and durability to resist stress-cracking caused by the temperatures of freezing, frozen storage, and reheating; and

(c) the impact strength, tensile strength, and tear resistance to protect the commodity from contamination, dehydration, freezer burn, or quality deterioration during the conditions of use. Any seams in the bag must provide the protective qualities equivalent to the body of the bag.

b. Packaging. Approximately 3 or 5 pounds (1.36 or 2.27 kg) of commodity must be packaged into a plastic-film bag and sealed. The bag must be of a width and length to accommodate proper space for filling and reheating. The bag must be sealed to protect the commodity from contamination, dehydration, and freezer burn. Metal clips, wire ties, paper-coated wire ties, and staples must not be used for sealing bags.

The **bag and seal must** be of a design and structure to **remain intact (sealed) and prevent leaking** when the commodity is reheated (by recipient) in a boiling water bath.

7. Packing. All packing materials must be new and clean, and must not impart objectionable odors or flavors to the commodity.

II.H.7.

a. Shipping containers. Shipping containers must: (1) be a fiberboard container; (2) be of such size to pack the commodity without slack filling or bulging; (3) protect the commodity against loss and damage; (4) withstand the variations in humidity and temperature during the conditions of use; and (5) have the combined facings weight, the bursting strength, and the compression strength (edge crush value) to withstand the stresses of handling, shipping, stacking, and storage.

(1) Container bottom. Flaps on the bottom of a shipping container must be securely fastened so the bottom remains securely fastened when the top of the container is opened.

(2) Final closure. Final closure of the fiberboard shipping containers must be secure and made with commercially acceptable filament-reinforced tape, plastic film packaging tape, non-metallic strapping, adhesive, or other similar types of materials that can be used for cold temperature storage conditions and that provide for safe handling of the commodity. Steel or wire straps must not be used for the final closure. Staples must not be used for the final closing of shipping containers. Adhesive or staples cannot be used to fasten the top portion of telescope-style containers to the bottom portion. However, staples may be used to manufacture and to assemble the shipping containers, provided the staples are fastened into the container and tightly clenched to eliminate sharp edges prior to packing the commodity into the shipping containers.

b. Packing. Ten 3-pound (1.36 kg) or six 5-pound (2.27 kg) packages of commodity must be packed in each fiberboard shipping container to 30 pounds (13.61 kg) net weight.

8. Organoleptic Requirements and Product Characteristics.

a. After packaging, a package of commodity will be sampled and examined for organoleptic requirements. If any sample does not comply with the organoleptic requirements, the product the sample represents will be rejected for use under this Specification. Additionally, the commodity will be evaluated for the product characteristics (defects) shown in Table 3. The frequency of sampling and the defects allowed will be in accordance with those outlined in Poultry Programs' SPL-2.

b. Production samples will also be evaluated, reviewed, and compared to a pre-bid sample (II.A.6.) to ensure compliance with the product characteristics found in Table 3 by USDA, Poultry Programs, Grading Branch supervisory personnel. The frequency of production sample review will be in accordance with Poultry Programs' "Sampling Requirements and Procedures for Turkey Taco Filling."

**Table 3. Organoleptic Requirements and Product Characteristics
for Cooked Commodity**

Organoleptic Requirements: Examined after packaging.	Criteria: The commodity must be free of: (a) rancidity; (b) metallic, overcooked, burnt, scorched, bitter, oxidized, stale, fruity, beany, oily, soapy, or other flavors or odors foreign to properly prepared and cooked turkey taco filling; and (c) foreign materials (e.g., glass, paper, rubber, metal).
Product Characteristics: Examined after packaging.	Must have the: texture, appearance, color, and flavor of properly prepared cooked turkey taco filling (i.e., similar to cooked ground beef in taco-seasoned sauce). See the “sample prototype” product characteristics as written in Poultry Programs’ “Source Selection Plan for Turkey Taco Filling,” dated July 2002 for additional requirements/information.
Texture:	Must have: moist, crumbled appearance and mouth feel, and be slightly firm, yet easy to chew.
Appearance:	Must have: distinct crumbled particles that do not stick/clump together, remain in large masses (retain package shape), or require that the commodity be physically separated with a fork or other utensil.
Color:	Must have the: color typical of similarly formulated and cooked meat products, not burnt, scorched, or under cooked.
Flavor:	Must have: a mild turkey taco-seasoned flavor that is not hot or spicy, not salty, not greasy, and does not have a prominent tomato flavor.

9. Reprocessing Cooked Commodity. Cooked and packaged commodity which does not meet the Specification requirements may be reprocessed provided the: (a) product is reprocessed within 8 hours from the time of cooking; (b) temperature of the cooked commodity has been lowered to not higher than 40 °F (4.4 °C) and not lower than 26 °F (-3.3 °C) if the product is held for longer than 8 hours; and (c) commodity is incorporated into raw formulated commodity (at a maximum of 5 percent of the formulated batch), packaged, cooked, and placed in a freezer within the 12 hours from the end of the shift it was produced.

10. Freezing. Immediately after cooking, the product must be placed under refrigeration where the internal product temperature of the cooked packaged commodity is continuously lowered. Cooling procedures used must be consistent with FSIS guidelines. The commodity must be packed and placed in a freezer within 12 hours of cooking. The internal temperature of the packaged and packed commodity must be continuously lowered to 0 °F (-17.8 °C) or lower within 72 hours from the time of entering the freezer. If any sample of the commodity does not comply with the freezing requirements, the product or lot the

samples represent will not be accepted for use under this Specification.

II.

I. Metal Detection

1. Requirements.

a. The commodity must be examined by a metal detection device must be capable of detecting metallic contaminants including, but not limited to, stainless steel shavings, metal clips, metal fragments from cutting equipment, and pieces of wire.

b. The commodity must be presented correctly within the detection field pattern of the device. Procedures used must be appropriate for the dimensions, location, and pattern of the detection field, the “orientation effect” on the sensitivity of the device, the environmental conditions, and the commodity.

2. Operating Efficiency and Procedures. The operating efficiency of the metal detection device will be determined hourly by a USDA grader by placing a detection test strip with a sphere of 440 stainless steel in the center of the detection field pattern. Poultry Programs will provide the detection test strips with the stainless steel sphere of the specified diameter.

a. The commodity must be examined after it is packaged or packed in shipping containers.

b. The USDA grader will use a detection test strip with a 3.00 mm (0.1181 inch) sphere for commodity examined in a package or a shipping container.

3. Contaminated Product. These guidelines do not relieve the contractor of the responsibility to provide a safe product. Commodity suspected of being contaminated with metal, or found to be contaminated with metal, will be handled in accordance with FSIS procedures.

4. Other Detection Procedures. Other procedures for examination of the commodity may be approved by the Deputy Administrator of Poultry Programs, in writing.

III. LABELING

USDA labeling (III.A.-D. and III.F.-G.) or commercial labeling (III.E.-G.) must be used. When USDA or commercial labeling is selected, both the packages and shipping containers within a purchase unit must be labeled in that format. THE CONTRACTOR MUST USE THE SAME LABEL FORMAT (EITHER USDA OR COMMERCIAL) WITHIN A PURCHASE UNIT.

III.

A. USDA Labeling Requirements

When is used, any deviation from labeling requirements in this Specification must be approved by the Contracting Officer, in writing, prior to the start of production.

1. Labeling Provisions. Labeling and marking of the shipping containers must be in accordance with this Specification. The name, address, and phone number of the manufacturer must appear on each shipping container.

2. Printing Requirement. Labeling and marking information must be water-fast, nonsmearing, of a contrasting color, clear, and readable.

B. USDA Labeled Packages

No labeling information is required on the packaging materials.

C. USDA Labeled Shipping Containers

1. Recycle Symbol and Statement. The contractor shall place somewhere on the surface of each recyclable shipping container the recycle symbol shown in EXHIBIT 1. The statement "PLEASE RECYCLE" is to be placed under the symbol. The recycle symbol and statement must be legibly printed in permanent ink.

2. Labeling and Marking Information.

a. Requirements. Labeling and marking information must be: (1) preprinted, stamped, or stenciled on each shipping container; or (2) printed on a pressure-sensitive label and applied to each shipping container. This information, in essentially the same layout, is provided in EXHIBITS 2 and 3.

b. "END" and "SIDE" designations. For the purpose of labeling and marking, the "end" and "side" panels may relate to the shortest and longest dimensions of the shipping container at the discretion of the contractor/processor. However, the panels must alternate between "end" panel and "side" panel designation with the two side panels and two end panels being located on opposite panels of the shipping container.

3. TOP PANEL - Labeling and Marking. The following information is required (as applicable) on the top panel of each shipping container:

a. Storing instructions. The following storing instructions must be printed on the top panel of the shipping container:

PERISHABLE--KEEP FROZEN
KEEP AT ZERO DEGREE F (-17.8 °C) OR BELOW

III.C.3.

b. USDA symbol and manufacturer identification. The following must be printed on the “top panel” or the “one end” designated panel of each shipping container:

(1) The USDA symbol, copy on back of Specification, is to be a minimum of 2.25 inches (5.72 cm) in height.

(2) The manufacturer’s name, address, and phone number.

4. ONE END Panel - Labeling and Marking. The following information is required (as applicable) on one end of each shipping container:

a. Type, name, and ingredients statement. The following is required on the “one end” designated panel of each shipping container:

FROZEN COOKED TURKEY TACO FILLING
Ingredients:

Ingredients must be listed by proper name and in proper order in accordance with FSIS regulations (9 C.F.R. § 381.118).

b. Inspection mark and plant number. The USDA inspection mark and USDA-assigned plant number must be printed on the “one end” designation panel of each shipping container.

c. Storing instructions. The following storing instructions must be printed on the “one end” designated panel of each shipping container:

KEEP FROZEN

d. Net weight. The net weight statement must be completed and printed on the “one end” designated panel of the shipping container:

___ Bags Net Combined Weight
30 LBS. (13.61 KG)

e. Nutritional labeling. A nutritional label, indicating the nutrient content of the commodity, is required on the “one end” designated panel of each shipping container. This nutritional facts information or "nutrition facts panel" must be in compliance with the FSIS nutritional labeling requirements.

(1) The contractor/processor must select one of the following methods of

providing the nutrition facts panel:

III.C.4.

(a) Preprinted on the “one end” designated panel of each shipping container; or

(b) Printed on a pressure-sensitive label and applied to the “one end” designated panel of each shipping container. The pressure-sensitive label must not cover or conflict with the labeling requirements of this Specification.

(2) NOTE: The nutrition facts information and panel must be approved per FSIS regulations prior to shipment of the commodity. The method of providing and location of this information for each shipping container (preprinted or pressure-sensitive label) must be indicated on the FSIS label application.

f. Contract number and pack date. The following information must be printed on the “one end” designated panel of each shipping container:

(1) Last five digits of the contract number as it appears in the acceptance wire.

(2) Date packed (month, day, and year).

g. Universal product bar code.

(1) A Universal Product Code (UPC), symbol and code, called Interleaved 2 of 5 (I 2/5), must appear on each shipping container. The complete code, including the check digit, must be printed in machine-readable and human-readable form. The start and stop indicators will be included in the bar codes. Printing, readability, and scanability of the bar code must be in accordance with UPC guidelines published by Uniform Code Council, Inc., 7887 Washington Village Drive, Suite 300, Dayton, Ohio 45459.

(2) The contractor will use the code furnished by USDA. USDA has acquired a unique manufacturer’s identification number for the commodity purchase programs and will use a unique item code number for the commodity purchased under this Specification. The contractors need not join Uniform Code Council, Inc.

(3) The 14-digit UPC code for shipping containers of commodity is:
1 07 15001 01565 2

(4) The UPC code must be placed in the lower right-hand corner of the “one end” designated panel of each shipping container.

h. USDA symbol and manufacturer identification. The following must be printed on the “top panel” or the “one end” designated panel of each shipping container:

(1) The USDA symbol, copy on back of Specification, is to be a minimum of 2.25 inches (5.72 cm) in height.

III.C.4.

(2) The manufacturer's name, address, and phone number.

5. ONE SIDE Panel - Labeling and Marking. No labeling information is required on the side panel immediately to the right of the "one end" designated panel.

6. THE OTHER END Panel - Labeling and Marking. No labeling information is required on the end opposite the panel designated "one end."

7. THE OTHER SIDE Panel - Labeling and Marking. No labeling information is required on the side opposite the panel designated "one side."

8. Inventory Control Label. The processor may use a pressure-sensitive label to place any additional information (including bar codes) for processor inventory control purposes. This label may be applied somewhere on the surface of the shipping container. The label must not cover or conflict with the labeling requirements of this Specification.

D. Use of Previously Printed USDA Labeling Materials

Carryover inventories of existing supplies of printed packing materials (USDA labeling) from the Commodity Specification for Turkey Taco Filling dated February 2002 may be used. If the ingredients statement, labeling of the ingredients, or nutrition facts information or panel changes from that printed on existing supplies, the contractor/processor must request temporary approval for use of carryover inventories from FSIS.

Shipping containers or labels with incorrect: (1) contract number, (2) plant number, (3) net weight, (4) date packed, (5) name of product, (6) ingredients statement, or (7) nutrition facts information or panel must be corrected before they are used. The incorrect information must be blocked out and the correct information legibly printed, stamped, or stenciled in permanent ink. Additionally, the name, address, and phone number of the manufacturer must appear on each shipping container.

E. Commercial Labeling Requirements

Commercially labeled packages and shipping containers must be labeled in accordance with FSIS requirements. Labeling must be approved by FSIS prior to acceptance for use under this Specification.

1. Distributor Labels. Commercial labels must be the manufacturer's own commercial label. Distributors' labels will not be allowed.

III.E.

2. Traceable Product.

a. The manufacturer must establish a product identification and record system that clearly links product by place and time of manufacture to specific USDA contracts and destinations. When the company uses the same commercial label for the product certified as complying with this Specification and commercial product, the identification system must differentiate between USDA and non-USDA products. An alpha numeric code may be used for information that is in addition to FSIS labeling requirements.

b. The required product identification and record system, including codes, must be reviewed by USDA before production begins for the contract(s). The USDA grader will include the product identification code on the USDA Poultry Grading Certificate that will accompany the product to destination.

F. Additional Labeling Issues

The following will not be accepted for use under this Specification:

- Commercial labels that do not have a manufacturer traceability system and code are not allowed.
- Commercial labeling traceability coding and systems that have not been reviewed by a representative of Poultry Programs, Grading Branch are not allowed.
- Distributor commercial labels are not allowed.
- Two or more different commercial labels are not allowed in the same purchase unit.
- Commercial labels and USDA labels are not allowed in the same purchase unit.

G. F.a.s. Vessel Deliveries

F.a.s. vessel deliveries that are not source loaded in a seavan are required to show the final destination's overseas address as provided in the Notice to Deliver. The address must be clearly printed on at least two sides of each pallet.

IV. FINAL EXAMINATION OF PACKAGED AND PACKED COMMODITY

A. Material and Net Weight Compliance

1. Verification of Materials and Defects.

- a. Verification of packaging and packing materials. Contractor must verify

compliance with packaging, packing, and marking material requirements by furnishing the

IV.A.1.

USDA grader the following certification on company stationery signed by a person authorized to do so by the contractor:

“(I) (We) certify that the packaging, packing, and marking materials used for any commodity presented for acceptance under the terms of the Commodity Specification for Turkey Taco Filling, dated July 2002, comply or will comply with the terms of this Commodity Specification.

Name _____

Title _____”

One certification is adequate for all production under this Specification.

b. Packaging defects. Packages in a delivery unit will be examined for defects that affect protection, expose product, or permit dehydration or freezer burn, or quality deterioration during storage, such as tears, holes, or improperly sealed or closed packages. The exterior of filled casings, bags, or pouches must be clean and free of product.

c. Packing defects. Shipping containers in a delivery unit will be examined for condition, labeling, and marking defects according to the United States Standards for Condition of Food Containers.

d. Tolerance for defects. If samples of packaged commodity or the shipping containers in a delivery unit have more defects than the maximum tolerance for the applicable Poultry Programs’ sampling plan, the delivery unit will be rejected.

2. Net Weight.

a. A purchase unit or delivery unit must total 39,000 pounds (17,690 kg) net.

b. Each delivery unit, except as provided in IV.A.2.g., will be examined for compliance with the net weight requirements at time of checkloading.

c. The tare weight of all packing materials will be determined by weighing a representative sample of all packaging components such as plastic-film bags and fiberboard containers.

d. Fifteen (15) shipping containers of commodity will be randomly selected from a delivery unit to determine net weight and must comply with the following:

(1) The total net weight of the 15 shipping containers must be equal to or greater than 450 pounds (204.12 kg).

IV.A.2.

(2) If the total net weight is less than 450 pounds (204.12 kg), but greater than or equal to 445.50 pounds (202.08 kg), the delivery unit will be accepted at a discount as stated in IV.A.2.e.

(3) If the total net weight is less than 445.50 pounds (202.08 kg), the delivery unit will be rejected (see IV.A.2.f.).

e. A delivery unit with the average net weight per container listed below will be accepted at the corresponding discount:

(Average Test Net Weight Per Container)

<u>Less Than</u>	<u>But Not Less Than</u>	<u>Contract Price Discount</u>
30.0 pounds (13.61 kg)	: 29.7 pounds (13.47 kg)	: 1.0%
29.7 pounds (13.47 kg)	: --	: Unacceptable

Payments will be made on the actual quantity delivered. All price adjustments will be based on a delivery unit.

f. Rejected delivery units may be reworked and reoffered one time only. However, if an individual shipping container in the sample of the reworked delivery unit has a net weight of less than 29.70 pounds (13.47 kg) the delivery unit will be rejected.

g. As an alternative to test weighing at time of checkloading, the contractor may request on-line verification of net weights. Upon receiving the request, a Federal-State supervisor, Grading Branch, Poultry Programs will determine that the facilities and procedures are in accordance with applicable Poultry Programs' instructions for this Specification.

B. Prerequisites for Loading and Shipping Frozen Commodity

1. Visual Inspection. Frozen commodity showing any evidence of defrosting, refreezing, or freezer deterioration will be rejected for use under this Specification.

2. Internal Product Temperature.

a. Requirements. The internal product temperature of frozen commodity must be 2 °F (-16.7 °C) or lower at time of loading. Delivery units with internal product temperatures exceeding 2 °F (-16.7 °C) and up to 5 °F (-15 °C) will be tentatively rejected. Tentatively rejected delivery units may be returned to the freezer and the temperature reduced to 2 °F

(-16.7 °C) or lower and reoffered one time only. Delivery units exceeding 5 °F (-15 °C) or delivery units that have been tentatively rejected and exceed 2 °F (-16.7 °C) when reoffered will be rejected for use under this Specification.

IV.B.2.

b. Optional temperature verification. As an option to verifying internal product temperature at time of loading, the contractor may request an alternate method utilizing product temperature sensing devices. If this option is selected, a Federal-State supervisor will determine that the facilities, equipment, procedures, and the contractors' current level of freezing compliance are in accordance with the established guidelines outlined in applicable Poultry Programs' instructions for this Specification.

C. Inspection and Checkloading

1. Requirements. Inspection for contract compliance will be made by a USDA representative, in accordance with 7 C.F.R. part 70, FSIS regulations, and this Specification, at site of processing, both during and after processing and packaging. A USDA representative may select samples for laboratory analyses or inspect the commodity at any point in transit and after delivery to point of destination. Inspection records must be complete and made available to USDA, as requested, to assure contract compliance.

2. Procedures. The inspection and checkloading required by Articles 54 and 55 of USDA-1 must be performed by a USDA grader. Procedures to be followed and a schedule of fees for these services may be obtained by contacting the nearest Grading Branch field office or the Chief of the Grading Branch, Poultry Programs, AMS, USDA, Room 3938-S, STOP 0258, 1400 Independence Avenue, SW, Washington, D.C. 20250, telephone (202) 720-3271. The quality, quantity, weight, packaging, packing, and checkloading of the commodity must be evidenced by certificates issued by the USDA grader. The contractor must not ship the commodity unless informed by the USDA grader that the designated lot or subplot to be shipped meets contract specifications.

V. UNITIZATION

Each delivery unit of commodity must be unitized (palletized and stretchwrapped) and comply with the following:

A. Pallets

Pallets must be good quality, wood, 48 inches x 40 inches, nonreversible, flush stringer, and partial fourway entry. Each pallet of shipping containers must be stretchwrapped with plastic film in a manner that will secure each container and layer of containers on the pallet. Palletized product must be loaded in a way that will prevent shifting and damage to the containers of product.

B. Pallet Exchange

Contractors may arrange for pallet exchange with consignees; however, USDA is in no way responsible for such arrangements.

VI. SHIPMENT AND DELIVERY

Shipment and delivery must be made in accordance with the Specification, the applicable Announcement and Invitation, and Articles 56, 57, and 64 of USDA-1, as amended by the Announcement. In addition, the contractor must adhere to the following provisions:

A. Contract Compliance Stamp

Each shipping container must be identified with a USDA Contract Compliance stamp with the applicable certificate number. A USDA grader, or other authorized personnel under the supervision of the USDA grader, will stamp one end of each shipping container prior to shipment. If there is inadequate space available on either end of the shipping container, the stamp may be applied to a side of the container.

B. Grading Certificate

A copy of the original USDA Poultry Products Grading Certificate issued at time of checkloading must accompany each shipment.

1. Railcar or Piggyback. If shipment is by rail or piggyback, the certificate must be placed in the railcar or trailer for easy access to the USDA grader, warehouseman, or consignee, as applicable.

2. Trucks. If shipment is by truck, the driver must, upon delivery, give the certificate to the USDA grader, warehouseman, or consignee, as applicable.

C. Loading and Sealing of Vehicles

Loading must be in accordance with good commercial practices and the sealing must be done at origin under the supervision of a USDA grader.

1. Railcar. Each railcar must be sealed. The contractors are responsible for arranging railcar deliveries of more than one delivery unit so that each delivery unit contained in the same railcar can be completely separated and sealed.

2. Truck or Piggyback. Truck or piggyback shipments must be sealed at origin. A delivery unit shipped by truck or piggyback which includes split deliveries to multiple destinations will not require separation by sealing each drop.

D. Delivery Notification

Notwithstanding the provisions of Article 56(c) of USDA-1, as amended by the applicable Announcement, the contractor must follow the instructions in the Notice to Deliver issued

by the Kansas City Commodity Office (KCCO) concerning delivery notification. Such notification and information of impending delivery are vital in proper execution of delivery. The contractor must notify the State distributing agency and the consignee of shipment per

VI.D.

instructions in the Notice to Deliver. For rail or piggyback shipments, notification shall be made on the day of shipment. For truck shipments, notification of the estimated arrival time should be made as far in advance of delivery as possible. In addition, for truck or piggyback shipments, the contractor must request and keep scheduled appointment(s). Unloading appointments for truck or piggyback shipments must be requested from the consignee contact party(ies) at least 24 hours in advance of delivery.

1. In-Plant Deliveries. When in-plant delivery is made, the contractor must notify the appropriate USDA resident grader and furnish applicable information.

2. Delivery In Storage. Delivery may be made in store provided the destination in the Notice to Deliver and the place the contractor has the commodity in storage are the same. Inspection and certification by a USDA grader are also required for transfers in store.

E. Split Deliveries

The contractor is responsible to deliver the quantity stated on each Notice to Deliver to each destination. Contractors must provide to the USDA grader, at time of shipment, the number of boxes and pounds for each destination.

At the option of the contractor, a purchase unit with two or more Notices to Deliver (split deliveries) for multiple destinations may be delivered on separate trucks provided each truck ships the total quantity stated on the Notice to Deliver. Any additional costs will accrue to the contractor's account.

VII. DESTINATION EXAMINATION

The cost of a destination examination, before or after delivery, by a USDA grader on accepted product will be for the account of USDA. Costs for destination examinations of rejected delivery units will be for the account of the contractor. The USDA origin grader will make arrangements for destination examination prior to delivery.

A. Commodity Requirements

Before acceptance by consignee, the commodity may be examined by a USDA grader on a spot-check basis for temperature, condition, identity, and when applicable, count. The commodity may be examined for conformance to contract provisions at any time required by the Contracting Officer.

VII.

B. Temperature

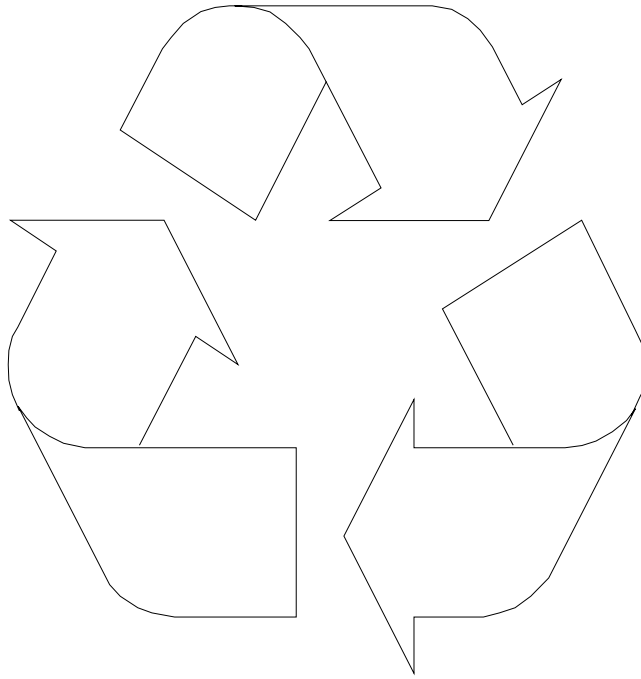
The commodity must arrive at destination at an average internal product temperature not to exceed 10 °F (-12.2 °C) with no individual temperature exceeding 15 °F (-9.4 °C).

Commodity not meeting these requirements will be rejected for use under this Specification.

Howard M. Magwire
Deputy Administrator, Poultry Programs

Attachments

EXHIBIT 1
“Please Recycle” Symbol and Statement



**PLEASE
RECYCLE**

EXHIBIT 2
USDA Labeled Shipping Containers

Marking Information: Shipping containers may be marked substantially as shown below. Detailed USDA labeling information is provided in Exhibit 3. Markings must be preprinted, stamped, stenciled on containers, or printed on a separate pressure-sensitive label and applied to containers. The USDA symbol is to be a minimum of 2.25 inches (5.72 cm) in height and may be printed on the “TOP PANEL” or “ONE END” designated panel. The manufacturer’s name, address, and phone number may be printed on the “TOP PANEL” or “ONE END” designated panel.

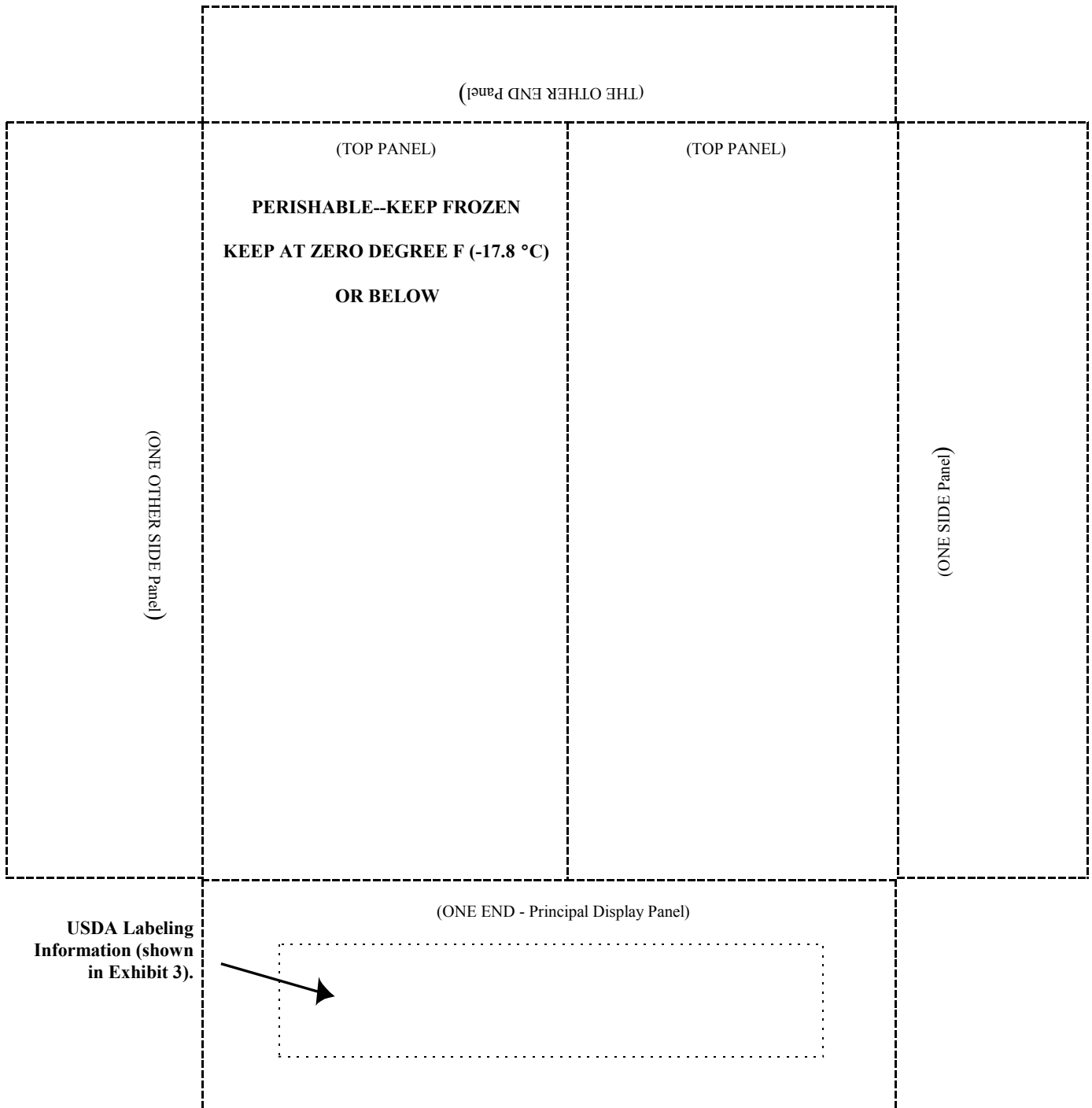


EXHIBIT 3
USDA Label Information for
Turkey Taco Filling

Marking Information: USDA labeling information must be printed on the “ONE END” panel of each shipping container as provided in Exhibit 2. Markings must be preprinted, stamped, stenciled on containers, or printed on a separate pressure-sensitive label and applied to containers. The UPC 14-digit I 2/5 code (1 07 15001 01565 2), bar and code, must be shown in the lower right-hand corner of the “ONE END” designated panel. The USDA symbol must be a minimum of 2.25 inches (5.72 cm) in height and may be printed on the “TOP PANEL” or “ONE END” designated panel. The manufacturer’s name, address, and phone number may be printed on the “TOP PANEL” or “ONE END” designated panel.



FROZEN COOKED
TURKEY TACO FILLING

Ingredients:



**Manufacturer’s Name,
Address, and Phone Number**

**Nutrition Facts Panel
May Be Placed Here**

KEEP FROZEN

__ Bags Net Weight
30 LBS. (13.61 KG)

CONTRACT NO. _____
DATE PACKED Month, Day, and Year

UPC Bar and Code

USDA SYMBOL

